	Work	Order	ID	66943
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Page 1

Thursday, March 03, 2011 8:45:08 AM Item ID: D3278-2 Accept Setup Start **Revision ID:** Stop Item Name: Support **Start Date:** 3/3/2011 **Start Qty: 30.00 Cust Item ID:** Req'd Qty: 30.00 Required Date: 3/11/2011 **Customer:** Reference: Run Start Date: 1/-03-3 Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Reject Reject Operation Set Up/ Tool ID Tool # Plan Accept Insp. Description Work Center ID Qty Qty **Run Hours** Code Number Stamp **Draw Nbr Revision Nbr** D3278 Rev C 100 0.00 SHEAR me 11/03/16 0.00 Bandsaw Memo Jeaspa Bandsaw Cut blank: 2.00" x 1.00" x 2.550" long 110 0.00 HAAS CNC VERTICAL MACHINING #1 0.00 HAAS 1 Memo 1- Machine as per Folio FA405 and Dwg D3278 -2- Deburr and HAAS CNC vertical machine #1 Tumble ☐ Identify as D3278-2 120 QC2- Inspect parts off machine FAI/FAIB

Quality Control

Memo

DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr QC Inspector

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	! :	Date:

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			WORK ONDE	IN MON-COM CHIMAIN	JE (NON)			
	Description of NC Corrective Action Section B			Verification	Approval	Annroyal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
		,						
								*

NOTE: Date & initial all entries

NOD.

Work Order ID 66943

Page 2

Thursday, March 03, 2011 8:45:08 AM

Item 1D:

D3278-2

Accept



Setup Start

Stop



Revision 1D:

Item Name: **Start Date:**

Support

3/3/2011

Start Qty: 30.00

Req'd Qty: 30.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Run

Start

Required Date: 3/11/2011

Date:

SPC (Y/N):

0.00

0.00

Date:

Tool # Plan

Code

Stop

Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID**

130

Quality Control

Operation Description

Set Up/ **Run Hours**

M.A 11/03/22

Tool JD

31

Qty

Accept

Reject

Qty

140

HandFinish

Hand Finishing

QC8- Inspect parts - second check

Memo

Chemical Conversion Coat per OSI005 4.1

Memo

0.00

0.00

0.00

BR 11-3-22

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

31 BR 11-3-23

W/O:			WC	RK ORDER CHANGE	S			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						ļ		
Part No	*	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA: _	Date: _	
	R	esolution:	Disposition	າ:	QA: N/C Cld	osed:	Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORMAN	ICE (NCR)		110
D.4TF		Description of NC		Corrective Action Section	Ve		on Approval	I Approval
DATE STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector		
		·						HILLIAN THE

Work Order ID 66943

Page 3

Thursday, March 03, 2011 8:45:08 AM

Item ID: **Revision ID:**

Item Name:

D3278-2

Accept

Setup Start



Stop

Start Date:

Required Date: 3/11/2011

Support 3/3/2011

QC:

Start Qty: 30.00 Req'd Qty: 30.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject

Insp. Stamp Number

170

Packaging

Packaging

Identify as per dwg & Stock Location

0.00

0.00

SB 11/03/23

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

11/3/23 A) N(10-03-23

W/O:			V	VORK ORDER CHAN	GES				
DATE	STEP	PRO	OCEDURE CI	HANGE		Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Ca	itegory:	NCR:	Yes N	lo DQA :	Date: _	
	Re	esolution:	Disposi	tion:	QA: N	I/C Clo	sed:	Date: _	
NCR:			WORK OR	DER NON-CONFORM	IANCE ((NCR)			
DATE	CTED	Description of NC Corrective Action			Section B		Verificatio	n Approval	Approval
DATE	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspecto
		,	,						

Picklist Print

Thursday, March 03, 2011 8:45:14 AM

Work Order ID: 66943

Parent Item: D3278-2

Parent Item Name: Support

Start Date: 3/3/2011

Required Date: 3/11/2011

Page 1

Start Qty: 30.00

Required Qty: 30.00

Comments:

1PP: □A□04.04.19□New issue□KJ/JLM□

IPP B 07.09.06

Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00		Purchased	No			100	f	53.4303	0.2337	7.38			



6061-T6 Bar 1.00 x 2.00

Location	Loc Qty	Loc Code
MAT	51.972	
112567	0	

114415 3.75 115045 3.902 115952 40 116623 4.32 MAT03 1.4583 112567 1.4583

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PR	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part No	*	PAR #:	Fault Cat	egory:	NCF	: Yes I	No DQ	A:	Date: _	
	Re	solution:							Date:	
NCR:			WORK ORE	ER NON-CONFORM	IANCE	(NCR) . 			
DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	ction B	Sign &	Verific	ation	Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
								,		
								4		

DART AEROSPACE LTD	Work Order:	469.43
Description: Support	Part Number:	D3278-2
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+0.005/-0.000	8.099			Vein H	レ ア
+/-0.005		_		1,	
+/-0.010				1 (
+/-0.010	1			1(
+/-0.005	1.480	_			
+/-0.010	1 .	_		Rad-rage	
+0.005/-0.004	1				-7
+/-0.010	2.440	_		/)	
+/-0.010	1.980			11	
+/-0.030	1			Rad rage	
+0.005/-0.000	1			Veinni	-7
+/-0.010	1 1			Rod-mas	o
+/-0.010				Verny	V-7
+/-0.010				11	
+/-0.010	3			Rad-ra	
+/-0.030	R1.00			1,	•
+/-0.010	1.718	-		Vern M	12-2
+/-0.010				Rad-61	مه
+/-0.010	1			Vern	17
	+0.005/-0.000 +/-0.005 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +0.005/-0.004 +/-0.010 +/-0.030 +0.005/-0.000 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.010	Dimension +0.005/-0.000 Ø. 099 +/-0.005 .359 +/-0.010 .4/3 +/-0.010 .255 .4/80 +/-0.005 .4/80 +/-0.010 R. 125 +/-0.010 R. 125 +/-0.010 R. 130 +/-0.030 R. 130 +/-0.030 R. 130 +/-0.010 R. 258 +/-0.010 R. 258 +/-0.010 R. 258 +/-0.010 R. 400 +/-0.030 R. 100 +/-0.030 R. 100 R. 400 +/-0.030 R. 100 R. 400 +/-0.030 R. 100 R. 100 +/-0.030 R. 100 R. 100	Dimension +0.005/-0.000 &. 099 -	Dimension +0.005/-0.000 & . 099 -	Dimension Inspection

Measured by:	Audited by:	A.B.	Prototype Approval:	N/A
Date: 11/03/18	Date:	11/03/22	Date:	N/A

Rev	Date	Change	Revised by A	pproved
Α	04.04.19	New Issue P/O D3278-041	KJ/JLM	
В	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM ,	
С	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC X	E

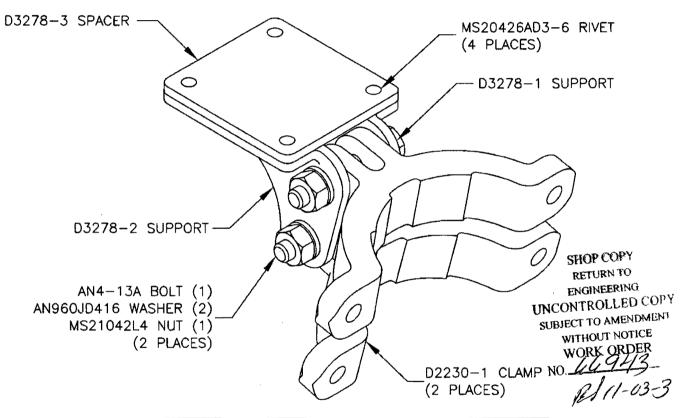
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		-								
Part No:		PAR #:	Fault Categ	jory:	NCR:	Yes N	lo DQ .	A:	_ Date: _	
Resolution:		Disposition:			QA: N/C Closed: Date:					
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of NC			tion B	N:		ation	Approval	Approval
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		-P	att -	D3278 SHEET	1 OF 3				
	DATE			TITLE	SCALE				
	07.0	07.24		SUPPORT ASSEMBLY	NTS				
	Α		04.03.03	NEW ISSUE					
	₿		05.03.31	CHANGE DIM/TOL TO ENSURE FIT					
	C		07.07.24	CHANGED RIVETS PER PAR #185					



D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

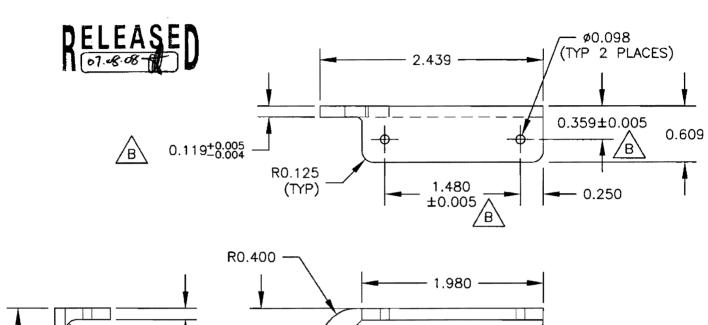
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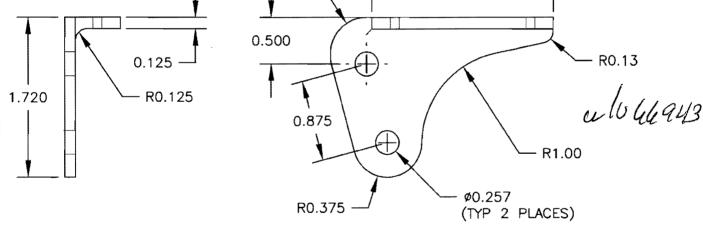
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CHECKED	APPROVED	DRAWING NO.		REV. C
A	—	D3278		SHEET 2 OF 3
DATE		TITLE		SCALE
07.07.24		SUPPORT A	ASSEMBLY	1:1





D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6B)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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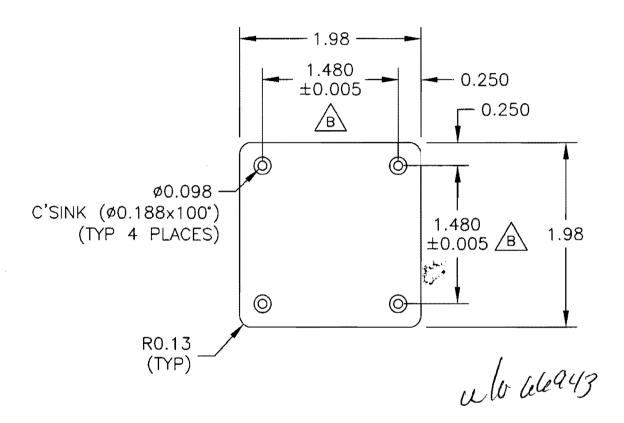
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Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA:	Date: _				
Resolution:			Dispositi	on:	QA: N/C CI	QA: N/C Closed: Date:					
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCR)					
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DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			

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1 4	- 	D3278	SHEET 3 OF 3
DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1





D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
 (REF. DART SPEC. M-DELRIN-B0.125×2.000) OR
 DELRIN II 150E OR ACETRON GP ACETAL
 (REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Cat	egory:	NC	R: Yes	No DQ	A:	Date:			
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